



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBT18560-3
Job Sheet 178485



Part No: RBT18560-3

Job Qty: 6 ea

DAS

Part Name: Ring

21

9-89



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/31/18

Job Tracking No:

Due Date: 10/29/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RBT18560 Rev 4 IPP Rev A 17.11.13 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		10/29/18	0.00	0.00	Start Up Machining-4		
100	Bandsaw	6 pcs		10/29/18	0.00	0.60	Bandsaw1		
120	Mori Seiki	6 pcs		10/29/18	0.00	3.00	MORI SL2500Y		
150	QC	6 pcs		10/29/18	0.00	0.00	QC2 Machining-4		
151	QC	6 pcs		10/29/18	0.00	0.00	QC8 Machining-4		
160	QC	6 pcs		10/29/18	0.00	0.00	QC5 Not required		
170	Outsource	6 pcs		10/29/18			GRO002-VC	5	
180	Packaging	78		10/29/18	0.00	0.00	Packaging2		
190	QC	6 pcs		10/29/18	0.00	0.00	QC6		
200	Packaging	6 pcs		10/29/18	0.00	0.00	Packaging3-2		
230	QC21-SA	6 Ea		10/29/18	0.00	0.00			

Part Op 90 - -35.25" makes 26 parts as per Eugene routing.

Descriptions: 100 - Cut blanks to 1.25"

120 - 1-Machine as per folio FB730 FOLIO REV: _____ DWG REV: _____ 2-Deburr

170 - -Issue P/O to Groupe Altech; PO 041547 -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-A513-T-2.625W0.250	A513 Seamless Alloy Steel Round Tubing 2.625"dia. x 0.250" Wall	.6600 ft (.11 ea)	90-Start up Operation	
		.756 (.108)		5012943

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MT-A513-T-2.625W0.250 Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL: 1 613 632-5200 Email: sales@dartaero.com www.dartaero.com	1	11	0

Container No: S122022



Part: RBT18560-3

Job No: 178485

Serial No/Batch: S122022

Revision: 4

Inspector:

Exp Date:

Instructions:

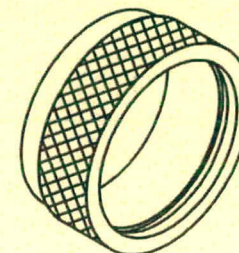
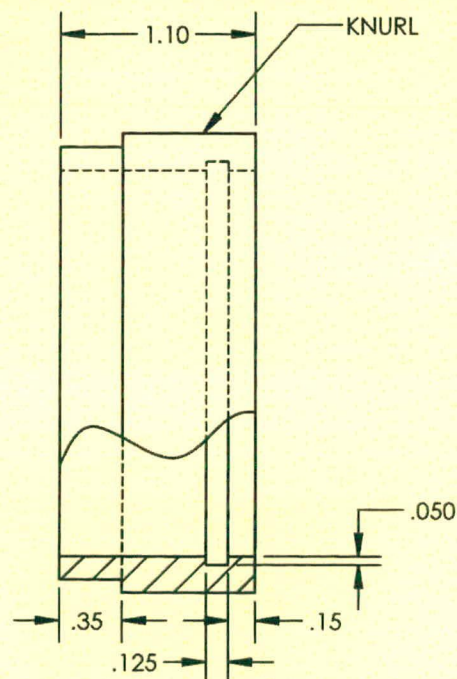
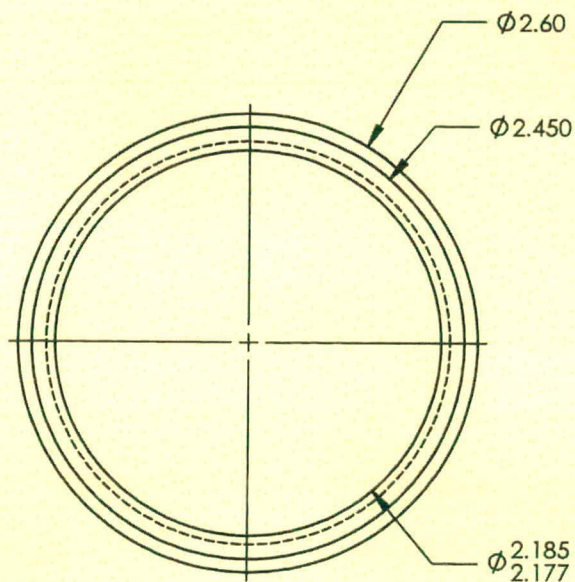
Date: 10/27/18

ex 10/19/18 3:33 PM DART.CHAREST-LACOMBE.JULIEN

9 88
26
DVS

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS			DATE	INITIAL	APPROVED
REV	ECR	DESCRIPTION			



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. ~~170256~~

170256 M/L
1801-12

(-3)
RING

DART AEROSPACE	
TITLE ENGINE/GEARBOX SEAL PULLER	
DWG NO. RBT18560-3	REV 4
MAT'L DOM HEAT TREAT FINISH BLACK OXIDE SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES XXX ± .005 FRACTIONS ± 1/8 XX ± .01 ANGLES ± 5° X ± .1 SURFACES = 125/✓
DRAWN BY: COLE	1. BREAK ALL SHARP EDGES .015 x 45° OR .016R
CHECKED:	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR:	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR:	USED ON MODEL
APPROVED: WEIL	SEE SHT 1
SCALE 1:1	DATE 5/2/2002
SHEET 3 OF 6	

32



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041549**

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO041549
PO Date: 11/1/18
Due Date: 11/11/18
Purchase Order Revision:
Revision Date:
Ship-To Contact: Tsimiklis, Chrisoula
Via: Ground
Pynt Terms: Net 60
Freight Terms:
Special Comments: Please confirm delivery date upon pricing

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	182153	RBST2812-P-13	Receiver -Issue P/O to GROUPE ALTECH; PO -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed	-	11/9/18	10 pcs	0 pcs	10 pcs	\$0.866/pcs	\$8.66

10 X NOV 10 2018

Line Item Note ** Need by Nov. 9, confirm if possible



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041549**

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
2	182157	RBST2812-P-7	Cap -Issue P/O to GROUPE ALTECH; PO -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-C-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 1018 -Certificate of Conformity is required	Firmed	-	11/8/18	10 pcs	0 pcs	10 pcs	\$0.866/pcs	\$8.66

10 X NOV 10 2018

[Signature]

Line Item Note ** Need by Nov. 9, confirm if possible

3	178485	RBT18560-3	Ring -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	11/9/18	7 pcs	0 pcs	7 pcs	\$1.35/pcs	\$9.45
---	--------	------------	---	--------	---	---------	-------	-------	-------	------------	--------

7X NOV 10 2018

[Signature]

DAS
38
9-89



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041549**

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	184265	RBE117-12020W17	Mount -Issue P/O to GROUPE ALTECH; PO -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 1144 Stress Proof -Certificate of Conformity is required	Firmed	-	11/9/18	8 pcs	0 pcs	8 pcs	\$3.20/pcs	\$25.60
5	185110	RBE117-12020W18	Pusher -Issue P/O to GROUPE ALTECH; PO -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 1144 Stress Proof -Certificate of Conformity is required	Firmed	-	11/9/18	4 pcs	0 pcs	4 pcs	\$3.45/pcs	\$13.80

8 X

NOV 10 2018

[Signature]

4 X

NOV 10 2018

[Signature]



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041549**

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
6	184470	RBT18700A-2	Bolt Modified -Issue P/O to GROUPE ALTECH; PO -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; Steel -Certificate of Conformity is required	Firmed	-	11/9/18	12 pcs	0 pcs	12 pcs	\$0.866/pcs	\$10.39
7	182152	RBST2812-P-11	Dual Seat -Issue P/O to GROUPE ALTECH; PO -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed	-	11/9/18	11 pcs	0 pcs	11 pcs	\$1.35/pcs	\$14.85

12x NOV 10 2018

11x NOV 10 2018

Line Item Note **Need for Nov. 11, confirm if doable**



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041549**

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
8	182158	RBST2812-P-9	Stud -Issue P/O to GROUPE ALTECH; PO -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed	-	11/9/18	10 pcs	0 pcs	10 pcs	\$0.866/pcs	\$8.66

10 X NOV 10 2018

[Signature]

Line Item Note **Need for Nov. 11, confirm if doable**

9	182154	RBST2812-P-15	Tensioner -Issue P/O to GROUPE ALTECH; PO -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed	-	11/9/18	10 pcs	0 pcs	10 pcs	\$0.867/pcs	\$8.67
---	--------	---------------	--	--------	---	---------	--------	-------	--------	-------------	--------

10 X NOV 10 2018

[Signature]

Line Item Note **Need for Nov. 11, confirm if doable**



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041549**

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
10	177797	RBEM652V3002101-M-27	Stud -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed -		11/9/18	13 pcs	0 pcs	13 pcs	\$0.866/pcs	\$11.26

13x NOV 10 2018

Line Item Note **Need for Nov. 11, confirm if doable**

Grand Total: \$120.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 11/5/18 10:32 AM dart.tsimiklis.chrisoula



Certificat de Conformité / Certificate of Compliance

(014102-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

014102-1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.		Bon de commande Client Customer Purchase Order No.			
09-Nov-2018		Aman			041549			
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBST2812-P-13 Rev. ✓	RBST2812-P-13 01-OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY A THIN LAYER OF OIL MIL-C-81309 TYPE 3 WIPE OFF EXCESS	OXIDE-BLACK CH	10	10 ✓	0	0	0
2	RBST2812-P-7 Rev. ✓	RBST2812-P-7 01-OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY A THIN LAYER OF OIL MIL-C-81309 TYPE 3 WIPE OFF EXCESS	OXIDE-BLACK CH	10	10 ✓	0	0	0
3	RBT18560-3 Rev. ✓	RBT18560-11 BLACK OXIDE FINISH MIL-C-13924C CLASS 1	OXIDE-BLACK CH	7	7 ✓	0	0	0
4	RBE117-12020W17 Rev. ✓	RBE117-12020W17 01-OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY A THIN LAYER OF OIL MIL-C-81309 TYPE 3 WIPE OFF EXCESS	OXIDE-BLACK CH	8	8 ✓	0	0	0
5	RBE117-12020W18 Rev. ✓	RBE117-12020W18 01-OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY A THIN LAYER OF OIL MIL-C-81309 TYPE 3 WIPE OFF EXCESS	OXIDE-BLACK CH	4	4 ✓	0	0	0
6	RBT18700A-2 Rev. ✓	RBT18700A-2 01-OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL MIL-PRF-16173 GRADE 3 CLASS 1	OXIDE-BLACK CH	12	12 ✓	0	0	0
7	RBST2812-P-11 Rev. ✓	RBST2812-P-11 01-OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY A THIN LAYER OF OIL MIL-C-81309 TYPE 3 WIPE OFF EXCESS	OXIDE-BLACK CH	11	11 ✓	0	0	0
8	RBST2812-P-9 Rev. ✓	RBST2812-P-9 01-OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY A THIN LAYER OF OIL MIL-C-81309 TYPE 3 WIPE OFF EXCESS	OXIDE-BLACK CH	10	10 ✓	0	0	0
9	RBST2812-P-15 Rev. ✓	RBST2812-P-15 01-OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY A THIN LAYER OF OIL MIL-C-81309 TYPE 3 WIPE OFF EXCESS	OXIDE-BLACK CH	10	10 ✓	0	0	0

DAS
38
9-89



Certificat de Conformité / Certificate of Compliance

(014102-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

014102- 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
09-Nov-2018		Aman		041549				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Quantités / Quantities Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
10	RBEM652V3002101-M-27 Rev. ✓	RBEM652V3002101-M-27 BLACK OXIDE FINISH MIL-C-13924C CLASS 1	OXIDE-BLACK CH	13	13 ✓	0	0	0

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.

